

Date: Friday, 22/08/2008 2:02:47 PM  
 User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DOUBLER  
 Job Number : 41605  
 Estimate Number : 12428  
 P.O. Number :  
 This Issue : 22/08/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D35061  
 Drawing Number : D3506 REV A  
 Project Number : N/A  
 First Issue : / / Type : MACHINED PARTS Drawing Revision : A  
 Material :  
 Previous Run : 28963 Due Date : 02/09/2008 Qty: 10 Um: Each  
 Written By :  
 Checked & Approved By : JLD 08.8.22  
 Comment : Est Rev:A New Issue 06-05-31 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S100 6061-T6 .100 Sheet



Comment: Qty.: 0.0082 sf(s)/Unit Total : 0.0819 sf(s)

6061-T6 .100 Sheet

(M6061T6S0100)

Batch: 102201

IB 8-9-10

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3506

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

IB 8-9-10

(15)

D 08/08/11 dm (15)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



IB 8-9-10

(15)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA640 and Dwg D3506

DJP 08/09/19

(15)

5.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



DJP 08/09/19

(15)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 22/08/2008 2:02:47 PM  
User: Julie Lecoq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 41605

Part Number: D35061

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*mk 08/08/19*

(15)

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
C'sink as per Dwg D3506(On Flat side)

*FF 08/10/01*

(15)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*5 08/10/02 7.5*

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

*08-10-02*

(15)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*08/10/02*

(15)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: *106*

*8/10/02*

(15)

*510*

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/10/03*

Job Completion



*08-10-03*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 41605
<b>Description:</b> Doubler		<b>Part Number:</b> D3506-1
<b>Inspection Dwg:</b> D3506 <b>Rev:</b> A		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	.132	*			
Ø0.404	+0.006/-0.001	.405	*			
0.750	+/-0.010	.749	*			
1.500	+/-0.010	1.499	*			
0.375	+/-0.010	.370	*			
0.750	+/-0.010	.750	*			
0.250	+/-0.010	.250	*			
0.098	+/-0.010	.099	*			

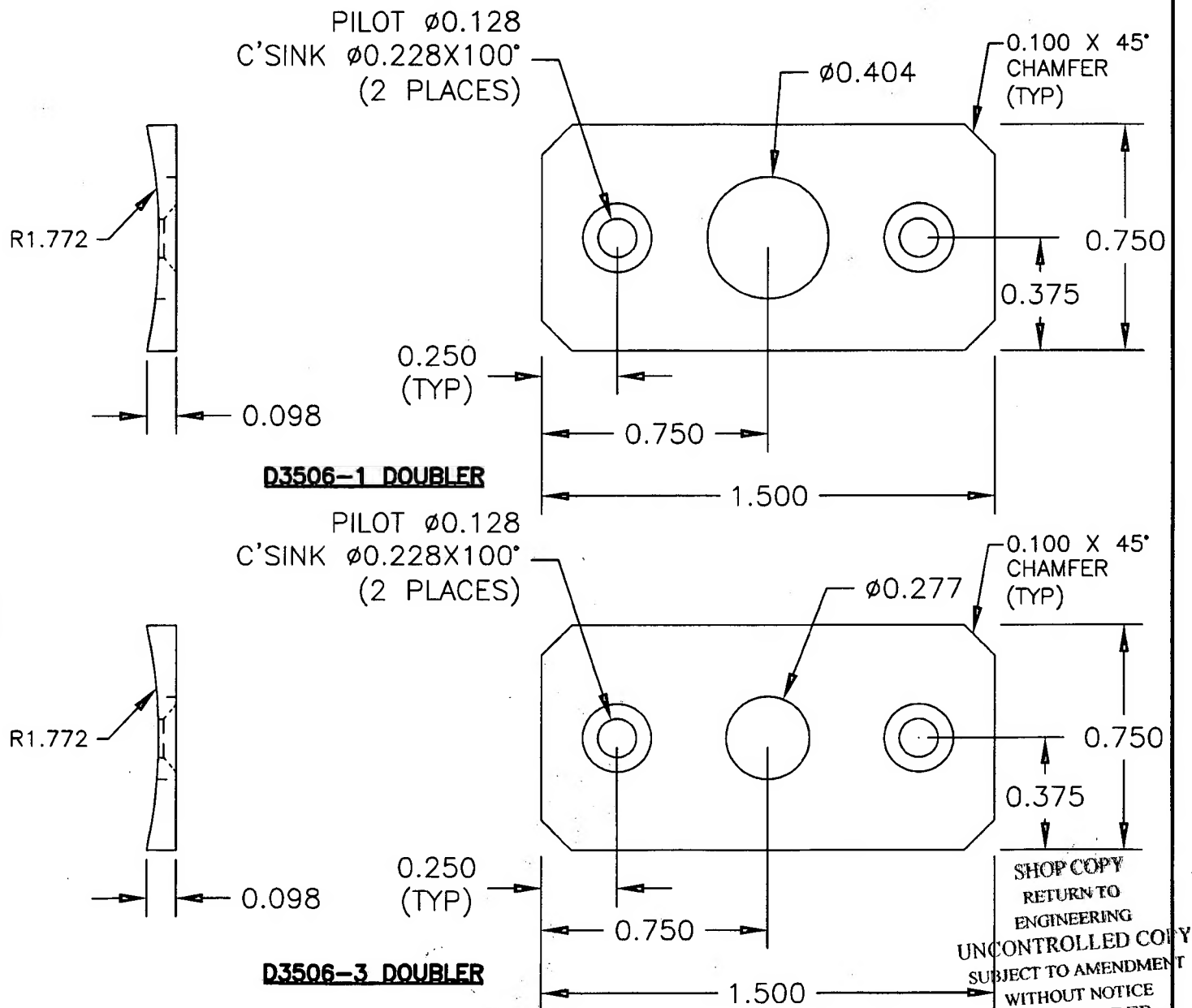
<b>Measured by:</b> B	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 8-9-16	<b>Date:</b> 08/09/19	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.09	New Issue	KJ/JLM [Signature]	[Signature]





DESIGN HH	DRAWN BY HH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED HH	APPROVED HH	DRAWING NO. D3506	REV. A SHEET 1 OF 1
DATE 06.04.21		TITLE DOUBLER	SCALE 2:1
A	06.04.21	NEW ISSUE	



**D3506-1/-3 DOUBLER**

- 1) MATERIAL: 6061-T6/T651 ALUMINUM PER QQ-A-250/11 (0.100 THICK)  
(REF DART MATERIAL SPEC M6061T6S.100)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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